

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

**(19) World Intellectual Property Organization
International Bureau**



**(43) International Publication Date
27 January 2005 (27.01.2005)**

PCT

(10) International Publication Number
WO 2005/007944 A3

(51) International Patent Classification⁷: D02G 3/02

KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD,
MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG,
PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM,
TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM,
ZW

(21) International Application Number: PCT/US2004/022262

(22) International Filing Date: 12 July 2004 (12.07.2004)

(25) Filling Language: English

(26) Publication Language: English

(30) Priority Data: 60/486,037 10 July 2003 (10.07.2003) U.S.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

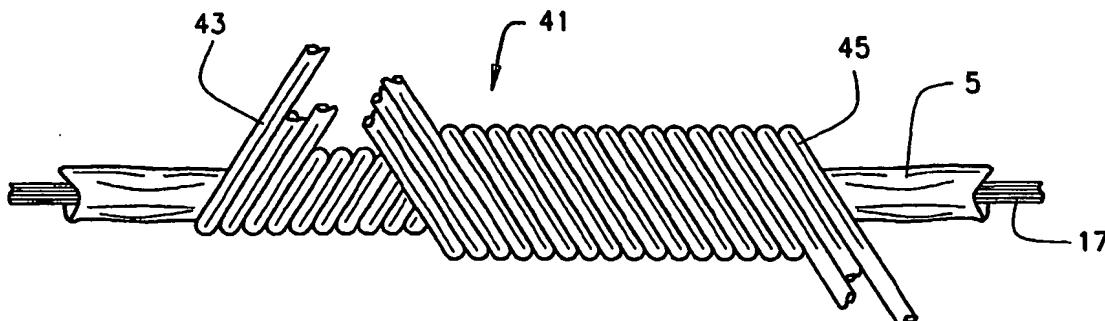
Published:

- *with international search report*
- *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments*

(88) Date of publication of the international search report:
8 December 2005

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: YARNS, PARTICULARLY YARNS INCORPORATING RECYCLED MATERIAL, AND METHODS OF MAKING THEM



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(57) Abstract: Enhanced performance yarns (41, 81) which comprise, and are functional and economic alternatives to, 100% petroleum oil based virgin continuous filament yarns, and yarns of natural fibers and methods of making them. The yarns may comprise an inner portion of spun staple fibers of recycled plastic and an outer portion comprising a different material and incorporate highly significant amounts of recycled plastics, particularly post consumer recycled (PCR), thermoplastic material such as polyethylene terephthalate (PET) which contains medium to high levels of contamination. One embodiment of yarn comprises a core (17), an inner portion (5) of spun staple fibers surrounding the core, and an outer portion (41) comprising an inner helix (43) and an outer helix (45) formed of a material different from the inner helix.